

Work Order ID 102554

May-30-13 3:23:14 PM

\*102554\*

Page 1

Item ID: 646.3711

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clip

Start Date: 5/30/13

Start Qty: 12.00

Cust Item ID:

Required Date: 6/10/13

Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-05-30

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3700	A

110

0.00

\*110\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

*Grain Direction!*

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

20 0 Jm 3-6-3

20 0 Jm 3-6-3

Work Order ID 102554

\*102554\*

Page 2

May-30-13 3:23:14 PM

Item ID: 646.3711

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clip

Start Date: 5/30/13

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 6/10/13

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
*130*						20			
QC	Memo	0.00							
Quality Control		13.63							
140	Form as per dwg	0.00							
*140*						19			
Brake NC	Memo	0.00							
Brake NC									
150	QC5- Inspect part completeness to step on W/O	0.00							
*150*						19			
QC	Memo	0.00							
Quality Control		13.63							

pto  
13/04/03

DQA: \_\_\_\_\_ Date: 13/06/18


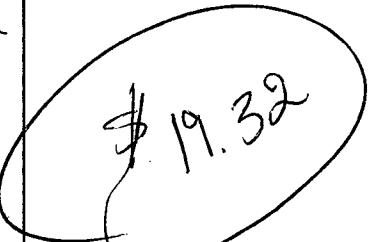


QA Closed: *ck* Date: *13/6/11*



### WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>102554</u> Part No. <u>644,3711</u> NCR No. <u>13,2725</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input checked="" type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
---------------------------------------------------------------------------------	-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	13/06/03	140	1	1 part was scrap at the set up  R.C. set up was not in place for Part. 1  <u>R.C. process</u>	 Q52042 13/06/03	Scrap & destroy No replace  	SA 13/06/03	 1363	 Q52042 13/06/03
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear		General			
<input type="checkbox"/> Bending	<input checked="" type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input checked="" type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			

# Work Order ID 102554

**\*102554\***

Page 3

May-30-13 3:23:14 PM

Item ID: 646.3711

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clip

Start Date: 5/30/13

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 6/10/13

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

160

Outsource process-Anodize per QSI017 4.1.10.1

0.00

**\*160\***

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG : 20070

1- Black Anodize as per Dwg 646.3700

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

CZ 13/06/03 (20)

170

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

13/04/04 (19)

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

13.66

19

# Work Order ID 102554

\*102554\*

Page 4

May-30-13 3:23:14 PM

Item ID: 646.3711

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Clip

Start Date: 5/30/13

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 6/10/13

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: 57835 0.00

\*210\*

Packaging

Memo

0.00

Packaging

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

43/6/12 (28)

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

13/6/10 (28)

MF  
13-6-7

# Picklist Print

May-30-13 3:23:14 PM

Page 1

Work Order ID: 102554

Parent Item: 646.3711

Parent Item Name: Clip

Start Date: 5/30/13

Required Date: 6/10/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.11.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			110	sf	259.7025	0.036	0.4547368 0.5			

Jm.3-6-3

Location	Loc Qty	Loc Code
MAT021	259.7025	
123135	120.2625	
124003	80.15	
125431	59.29	

DS431

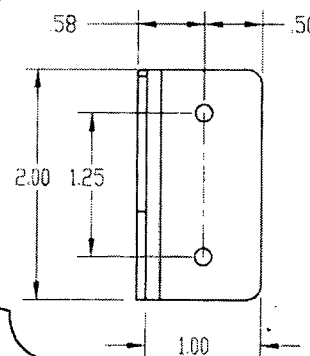
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS			EOR: D-12-010	

## SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11  
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

IS

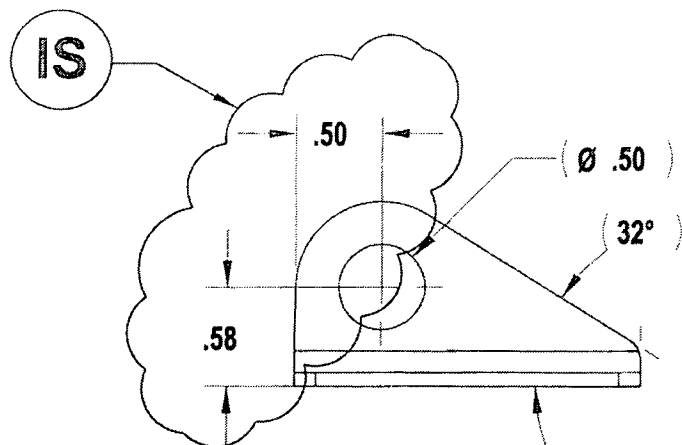


## SHEET 7, ZONE B1 IS:

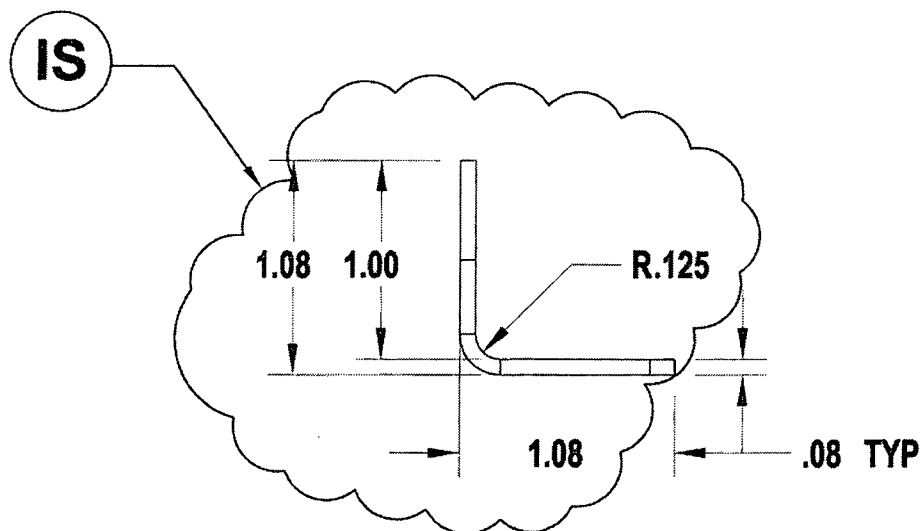
SHL  
R  
ENGINEER  
UNCONTROLLED  
SUBJECT TO  
WITH  
V.O. NUMBER  
NO. 102 SSY MCO  
13 05-30

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

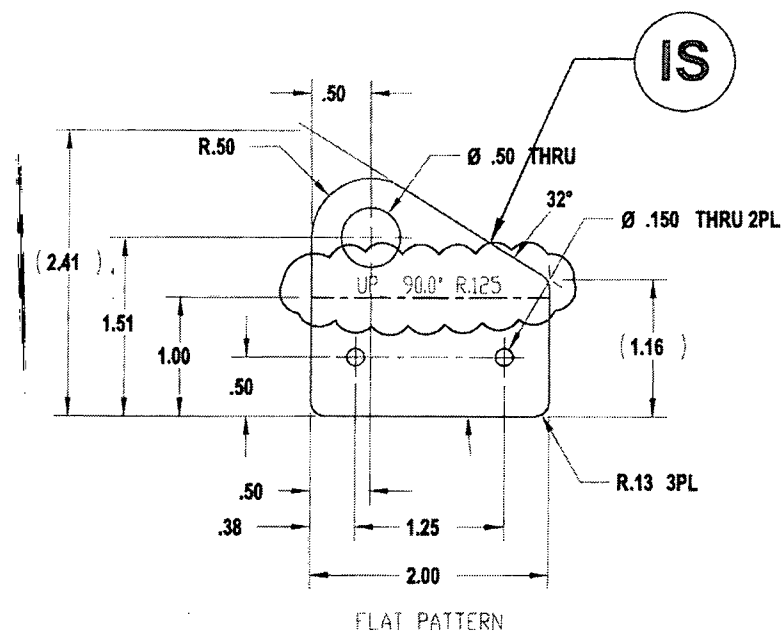
102554



**SHEET 7, ZONE C4 IS:**



**SHEET 7, ZONE D1 IS:**



**SHEET 7, ZONE B7 IS:**

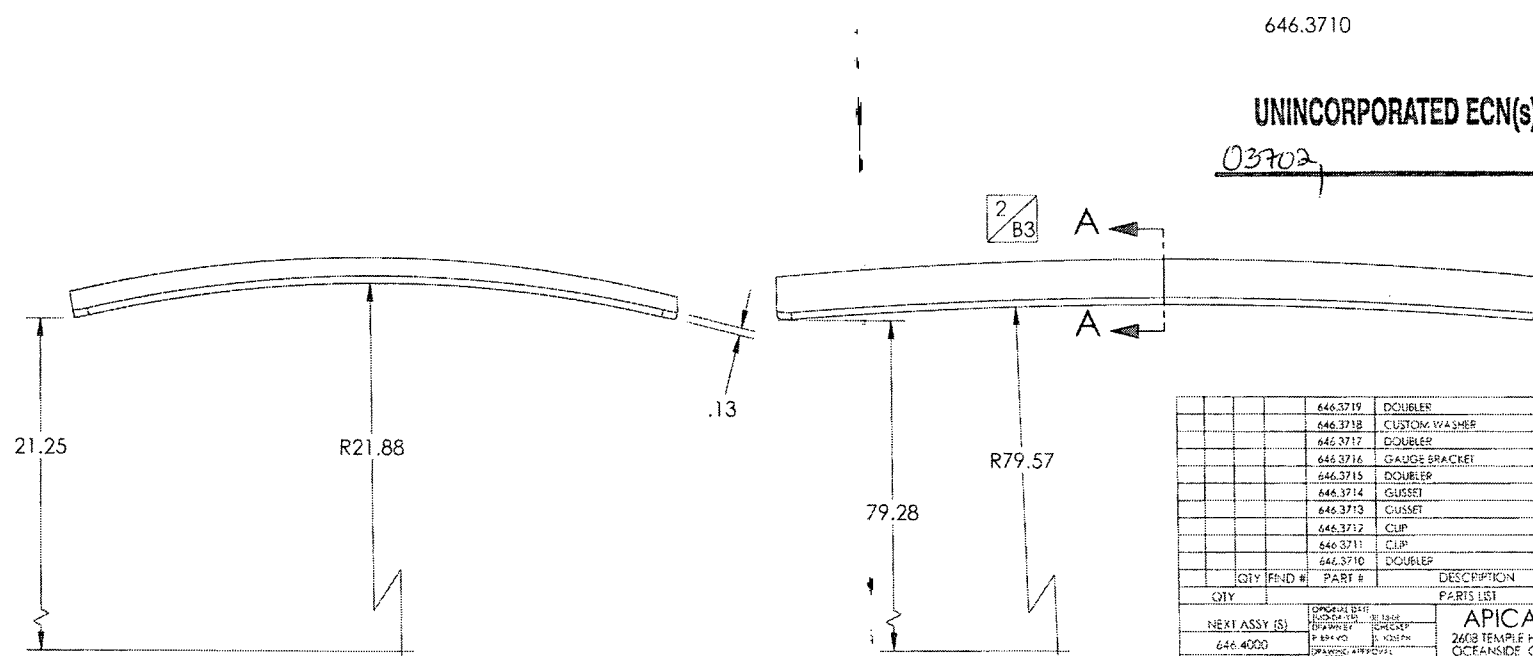
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------



102554

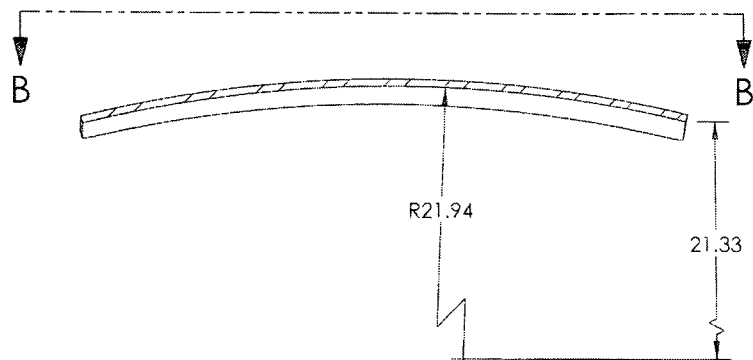
NOTES:

- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK  
CARDINAL 4860 50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5. DEBURR AND BREAK ALL SHARP EDGES
- 6. IDENTIFY IAW MPP-120

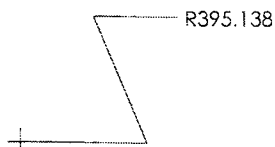


		646.3719	DOUBLER		
		646.3718	CUSTOM WASHER		
		646.3717	DOUBLER		
		646.3716	GAUGE BRACKET		
		646.3715	DOUBLER		
		646.3714	GUSSET		
		646.3713	GUSSET		
		646.3712	CLIP		
		646.3711	CLIP		
		646.3710	DOUBLER		

102554



SECTION A-A



R.13 4PL

13.51

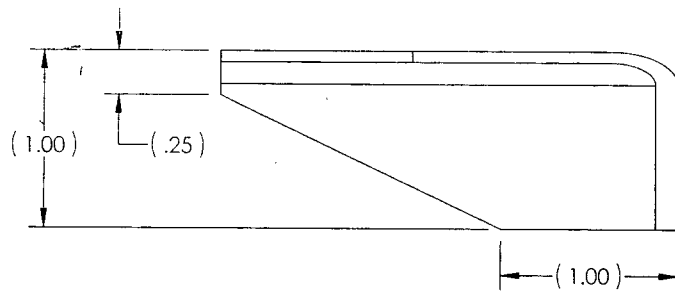
10.49

10.54

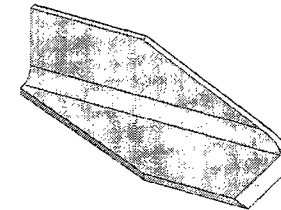
SECTION B-B

PROJECT NO. 102554 DRAWN BY: J. C. PETER CHECKED BY: J. C. PETER DATE: 10/25/16 SCALE: NONE	<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300
SHEETMETAL 646.3700 SCALE: NONE	SHEET 2 OF 6

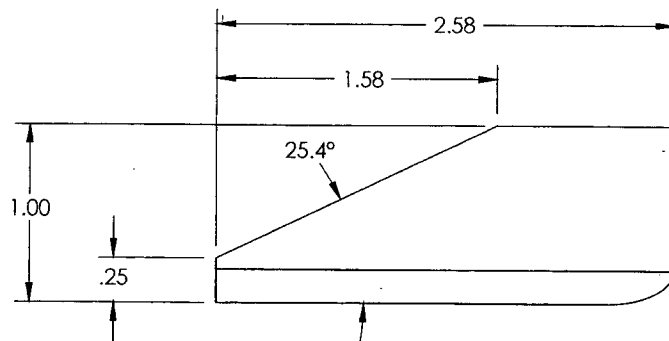
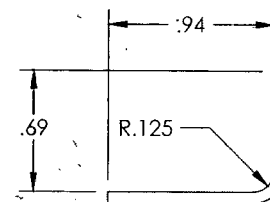
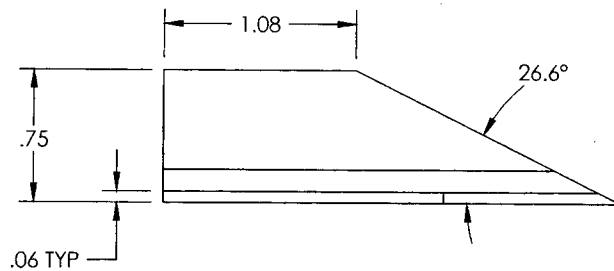
102554



Grain Direction



646.3711 SHOWN  
646.3712 OPPOSITE

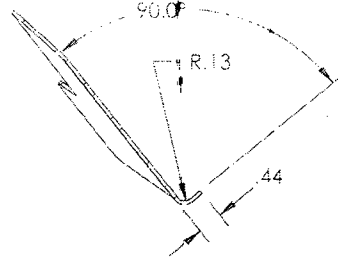


NEXT ASSY (S)	ORIGINAL DATE	06-18-08	
	DRAWN BY	CHECKED	
	P. BRAVO	S. JOSEPH	
	DEPARTING APPROVAL		
	UNLESS OTHERWISE SPECIFIED		
	DIMENSIONS ARE IN INCHES		
	TOLERANCES ARE:		
	2 PLACE DECIMALS ±.01		
	3 PLACE DECIMALS ±.005		
	ANGLES ±.5°		
SCALE: NONE		SHEET 3 OF 9	

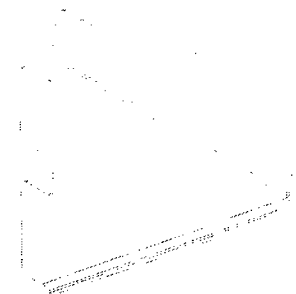
**APICAL INDUSTRIES**  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300  
**SHEETMETAL**

SIZE: 8" x 12" CAGE CODE: 07M26 DWG. NO. 646.3700 REV. A.1

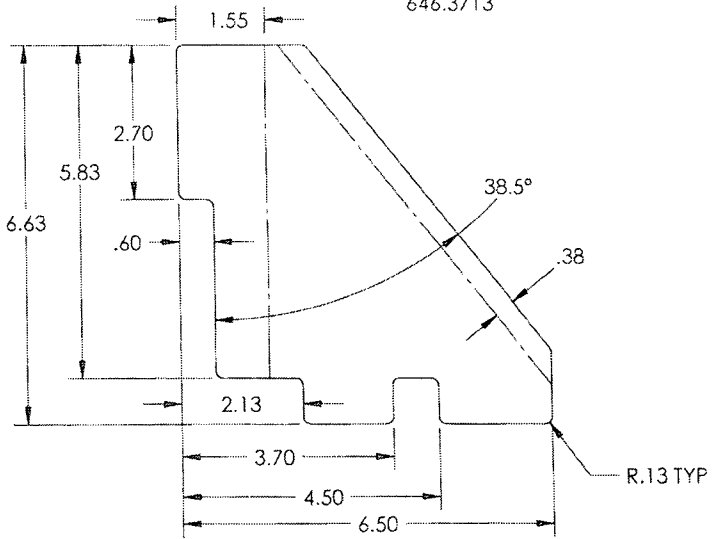
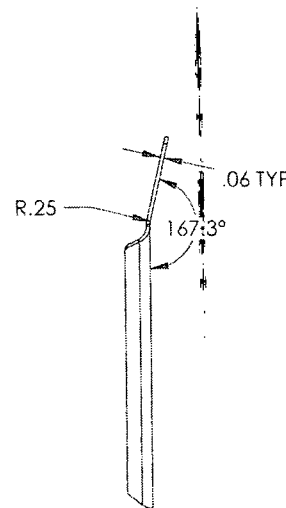
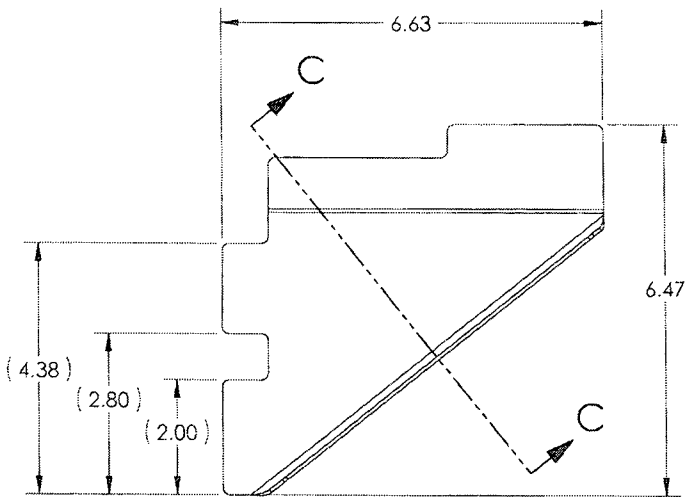
102JY



SECTION C-C



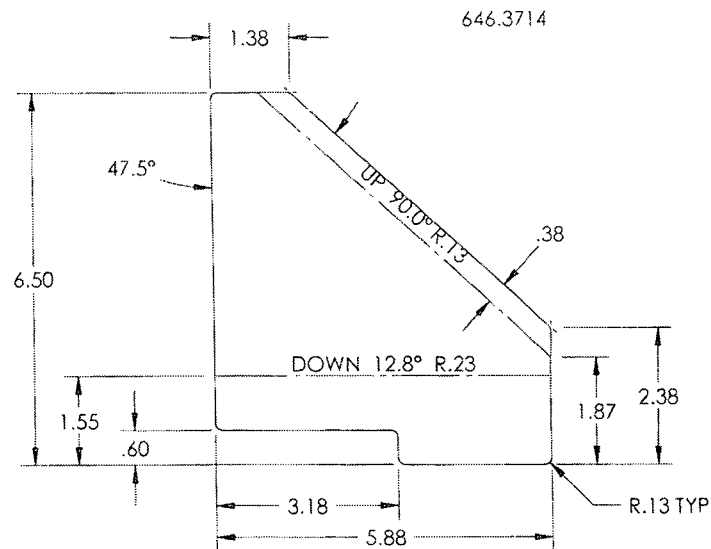
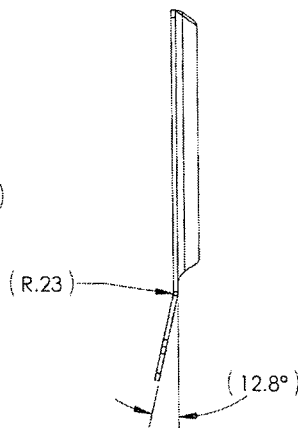
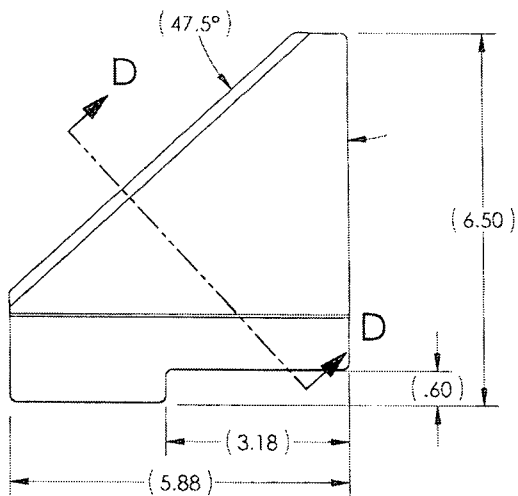
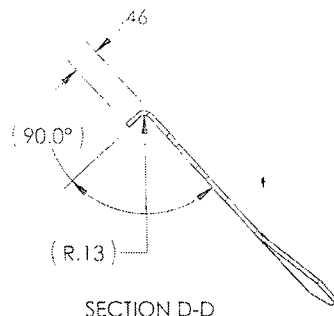
646.3713



FLAT PATTERN

NEXT ASSY. (S)	OPERATOR DATE	GB 15.02	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE CA. 92056-3512 (760) 724-5300	
	DESIGNED BY	DATE		
	DRAWN BY	DATE	SHEETMETAL	
	CHECKED BY	DATE		
	DATE		SEE (CAGE CODE) DRAW NO B 07M26 646.3700	
			SCALE: 1:1	
			SHEET 1 OF 2	

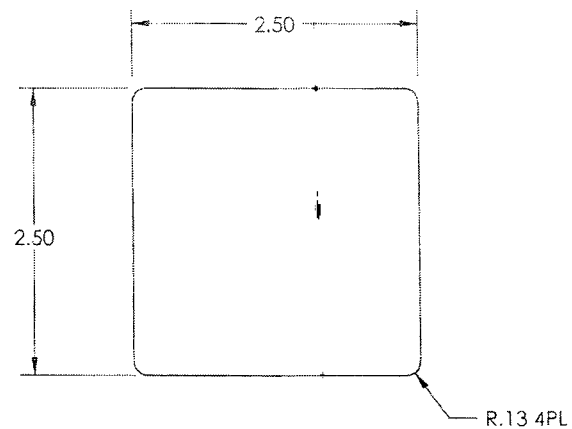
102554



FLAT PATTERN

<small>           APPROVALS            DESIGNED BY: J. J. J.            DRAWN BY: J. J. J.            CHECKED BY: J. J. J.            DATE: 10/25/94         </small>		<b>APICAL INDUSTRIES</b> <small>           2605 TEMPLE HEIGHTS DR.            OCEANSIDE, CA 92056-3512 (760)724-5300         </small>	
<small>           MATERIAL: 6061-T6 ALUMINUM            FINISH: ANODIZED         </small>		<b>SHEETMETAL</b>	
<small>           PART NUMBER: 646.3700            QUANTITY: 1000            SCALE: NONE         </small>		<small>           DATE: 10-25-94            BY: J. J. J.            CHECKED: J. J. J.         </small>	<small>           SHEET 5 OF 9         </small>

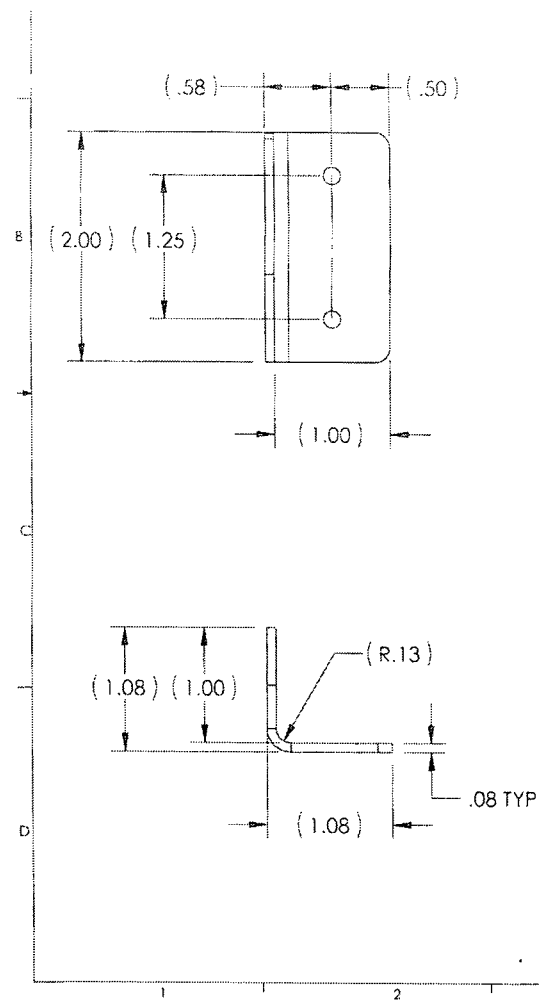
102554



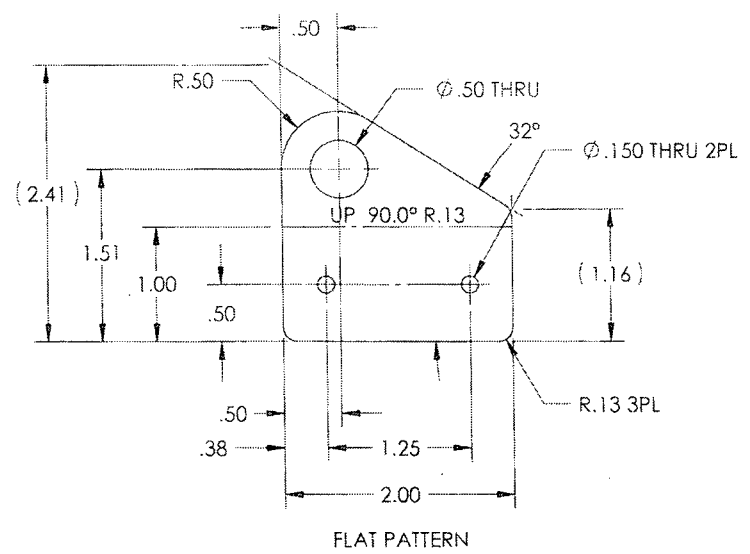
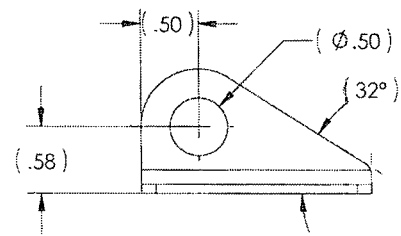
646.3715

NEXT ASSY. IS)	ORIGINAL DATE	06-18-08	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
	DESIGNED BY	D. JOSEPH				
	DESIGNED APPROVAL		SHEETMETAL			
	CONSTRUCTION					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMAL ±.01 3 PLACE DECIMAL ±.005 ANGLES ±.5°			SPT B	C/PQ CODE 07M26	DVS. NO. 646.3700	REV. A
SCALE: NONE			SHEET 4 OF 9			

102554



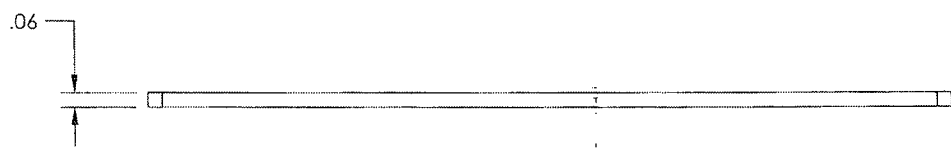
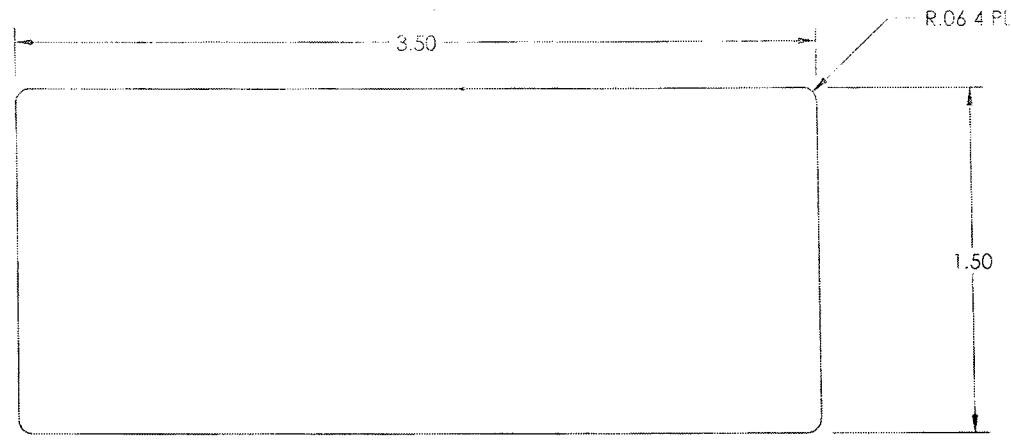
646.3716



FLAT PATTERN

NEXT ASSY IS)	ORIGINAL DATE	06-19-03	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DESIGNED BY	SCHECTER		
	P. DRA'G	J. JOSEPH		
	APPROVED BY	J. JOSEPH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE FRACTIONS DECIMALS 1/32 AND 1/16			REF. TO CH. CODE	DWG. NO.
			B	07M26
			SCALE	1/4" = 1"
			SHEET 3 OF 4	

102551

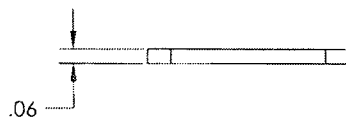
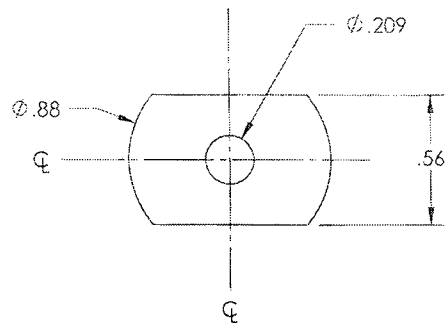


646.3717

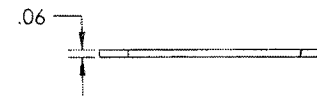
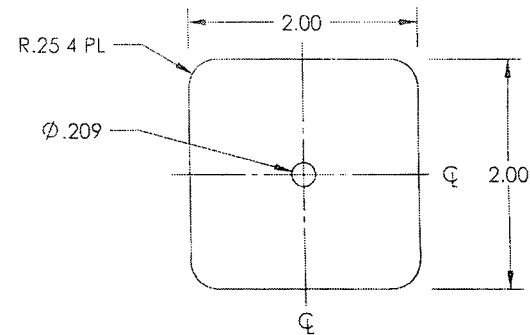
NEXT ASSY (S)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES	
DRAWN BY P. SPALCO		CHECKED BY J. COLEMAN	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY T. JOHNSON		DATE 08-18-08	SHEETMETAL	
OTHER COMMENTS				
ALL DIMENSIONS UNLESS SPECIFIED ARE IN INCHES AND DECIMALS TOLERANCES ARE: 2 PLACES DECIMALS ± .01 3 PLACES DECIMALS ± .001 ANGLES ± .2°		NET WEIGHT B 07M26	NET WT 646.3700	REV. A
		SCALE: NONE SHEET B CH 2		



102134



646.3718



646.3719

NEXT ASSY (S)	DESIGNED BY	08-18-06	APICAL INDUSTRIES	
	DRAWN BY	CHECKED		
	BY	DATE	2408 TEMPLE HEIGHTS DR.	
	DATE	DATE	OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNITS OF MEASURE SPECIFIED	SHEET CODE		SHEETMETAL	
	DWG NO.		646.3700	
	SCALE		1:1	
	SHEET # OF #		1 OF 1	





A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 62433

Date: 06-Jun-13

#### To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

#### Ship To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST  10 PCS 646.3310 10 PCS 646.3312 10 PCS 646.3313 10 PCS 646.3610  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N Job: 20130348 PO: 19997		Line: _____
1 lot	Part: ASST  20 PCS 646.3712 20 PCS 646.3716 19 PCS 646.3711  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N  12 PCS D4703-043 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20130347 PO: 20070		Line: _____
Certificate of Conformance			



A.T.G. Industries Inc.  
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PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
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Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE : <u>6/6/13</u>	
	CERTIFIED SIGNATURE : <u></u>	
	RECEIVER SIGNATURE : _____	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO20070

Purchase Order Date 6/3/2013  
PO Print Date 6/6/2013

Page Number 2 of 3

VC-ATG001

From :

T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-446-4544	Requisition Nbr	
Vendor Fax	613-446-4556	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: FINISH BLACK ANODIZE PER IAW MIL-  
A-8625 TYPE III,  
CLASS 2, COLOR BLACK

FINISH: PRIME AS PER IAW MIL-P-  
23377J TYPE I CLASS N

NOTE: THIS IS A RUSH ORDER  
REQUIRED FOR JUNE 6

3

102554

646.3711 CLIP

6/7/2013  
Yes

19.00 FedEx PI collect \$5.2261

\$99.3

Special Inst: FINISH BLACK ANODIZE PER IAW MIL-  
A-8625 TYPE III,  
CLASS 2, COLOR BLACK

FINISH: PRIME AS PER IAW MIL-P-  
23377J TYPE I CLASS N

NOTE: THIS IS A RUSH ORDER  
REQUIRED FOR JUNE 6

4

99919

647.4611 DEFLECTOR

6/7/2013  
Yes

5.00 FedEx PI collect \$0.0000

\$0

Special Inst: FINISH BLACK ANODIZE PER IAW MIL-  
A-8625 TYPE III,  
CLASS 2, COLOR BLACK

FINISH: PRIME AS PER IAW MIL-P-  
23377J TYPE I CLASS N

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required YES NO

Change Nbr: 2

Change Date: 6/6/2013